Quality Control

Friday, April 09	9, 2010 2:36:.	27 PM		# # # # # # # # # # # # # # # # # # # 						r	age .
Item ID: Revision ID:	D3953-19			Accept				Setu	ıp Start		
Item Name:	Gas Spring Br	racket							Stop		
Start Date: Required Date: Reference:	4/12/2010 : 4/13/2010	Start Qty: 12.00 Req'd Qty: 12.00	12 14 15 15 15 15 15 15 15		Cust Item I Customer:	D:		,		((11 1881
Approvals:	Process Pla	an: MF	Date: 10-4	7 Tooling:	Da	ıte:	· .	Rur	start		
	QC:		Date:	SPC (Y/N):	Da	ite:			Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan A Code Q			Reject Insp. Number Stan	
Draw Nbr	Rev	vision Nbr					,	:			
D3953	С	-	·	•							
Waterjet FLOW CNC Waterj	iet	Memo 1-Cut as per Dwg Rev:	Dwg D3953	0.00			_	B 10-L	4-12	\sim	
·) ~	Prog Rev:	-/	Debr-	m-1 10,	104/1	3			(6)	
110 		QC2- Inspect parts off m	achine FAI/FAIB	0.00			!	B10-1	4-12	- Story	

0.00

Memo

Dart	Aeros	pace	Ltd
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W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:NCR:NCR:NCR:NCR:NCR:NCR:NCR:NCR:NCR:									
Resolution:									
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NC	R)		• •	1844-1
		ļ	verifica			Approval	Approval		
			Initial	Action Description	Sign				
			1 1			& Sect			QC Inspector
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Work Order II	D 57607
Friday, April 09, 2016	0 2:36:27 PA



Page 2

Insp.

Stamp

M Item ID: D3953-19 Accept Setup Start **Revision ID:** Gas Spring Bracket Item Name: Stop **Start Date:** 4/12/2010 **Start Qty: 12.00 Cust Item ID: Required Date: 4/13/2010** Req'd Qty: 12.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: _____ Tooling: Date: Stop QC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Reject Accept Reject Work Center ID Description Run Hours Number Rev. Code Qty Qty Number 120 QC8- Inspect parts - second check 0.00 QC Memo Quality Control 130 0.00 Small Fab 0:00 Memo Small Fab 1- CHAMFER HOLE AS PER DWG 2- DEBURR IF NECESSARY 140 QC5- Inspect part completeness to step on W/O

Quality Control

QC

Memo

Dart	Aero	ospa	ce Ltd

W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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NCR:	10 1 No. 10		WORK ORD	ER NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC		n B	cation	Approval	Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 57607 Friday, April 09, 2010 2:36:27 PM





Page 3

Item ID:

D3953-19

Accept

Setup Start



Revision ID:

Item Name:

Gas Spring Bracket

Start Date:

4/12/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Approvals:

Required Date: 4/13/2010

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

150

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Draw Number Draw Plan Rev. Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

Quality Control

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PF	ROCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)	Date:								
Resolution:		Dispositio	n:	_ QA: N/C Cld	osed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)	7 100		
DATE	STEP		Initial					Approval	
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Picklist Print

Friday, April 09, 2010 2:36:27 PM

Work Order ID: 57607

Parent Item:

D3953-19

Parent Item Name:

Gas Spring Bracket

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC

dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as per

Start Date: 4/12/2010

Required Date: 4/13/2010 Required Qty: 12.00

Component Item ID/ Item Name

M304S11GA

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Measure sf

Qty on Hand 33.8200

Remaining Qty To Pick Issued 0.2274

Start Qty: 12.00

Qty 181

Date Issued

Status

Page 1

1B10-4-12

304/316 0.125 Sheet

Warehouse Loc Qty Loc Code Location Main Warehouse MAT19 33.82 112663 33.82

112663



Dart Aerospace	≥ Ltd
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W/O:			W	ORK ORDER CHANGE	S	-1-0.			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	By Date Qty Chief Eng / Prod Mgr Approval QC Inspector NCR: Yes No DQA: Date: QA: N/C Closed: Date: RMANCE (NCR) Section B Verification Approval Approval				
Resolution:									
NCR:			WORK ORD	ER NON-CONFORMAN	NCE (NCR)		· <u>.</u>	
DATE	STEP	Description of NC	A					Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Secti	on C	Chief Eng	QC Inspector
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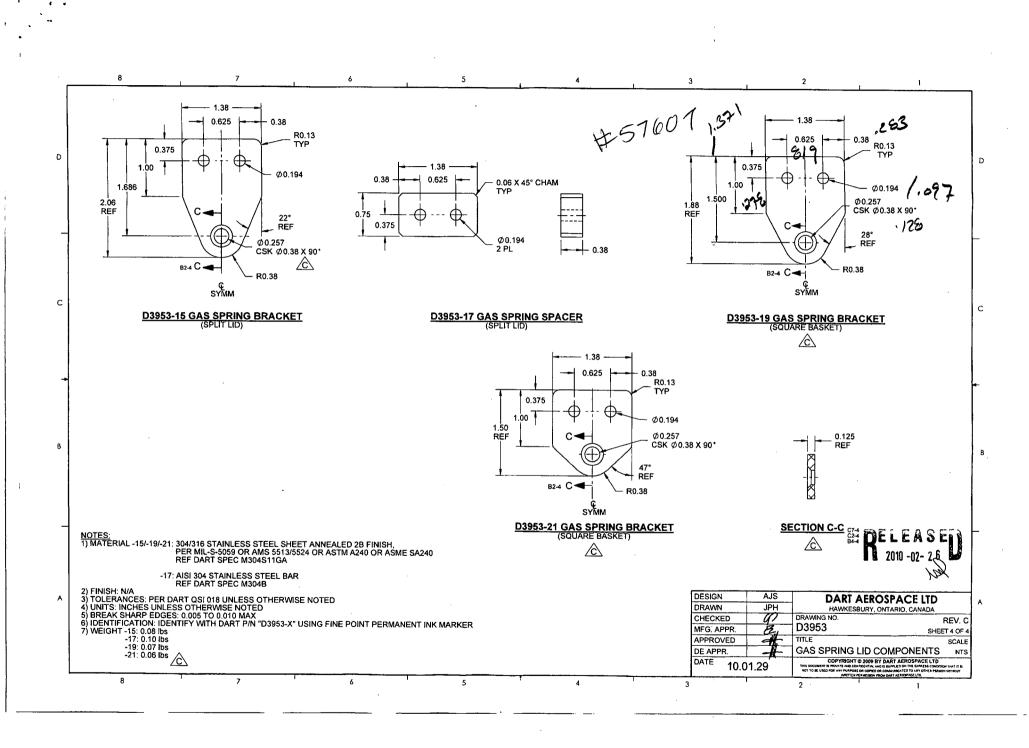
DART AEROSPACE LTD	Work Order:	57607
Description: Gas Spring Bracket	Part Number:	D3953-19
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRST ARTICLE INSPECTION CHECKLIST										
	X	First Artic	cle	Proto	otype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments				
Ø0.194	+0.005/-0.001	195	×								
Ø0.257	+0.006/-0.001	1358	7								
0.38	+/-0.030	185.	*								
1.38	+/-0.030	1.384	4								
0.625	+/-0.010	.627	<i>≽</i> 6								
0.375	+/-0.010	376	*								
1.00	+/-0.030	1,001	6								
1.686	+/-0.010	₫	3-15				<u></u>				
2.06	+/-0.030	C . UST		-							
0.125	+/-0.010	151,	>								
											
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							7.2				
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Measured by:	B	Audited by:	8		Prototype App	roval:	N/A				

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	Date:	C1-4-01		Date:	10/04/13			Date:	N/A	
Rev	Date	Change					Revis	ed by	Appro	ved
Α	10.03.31	New Issue				W-1-1	KJ	241	1	//
								7	7.	

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		•										
Part No:				NCR: Yes No DQA: Date:								
	R	esolution:						Date:				
NCR:		W	ORK ORE	DER NON-CONFORM	IANCE (N	CR)						
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		ction B	Sign &		ation	Approval Chief Eng	Approval QC Inspector		
			Chief Eng	Chief Eng	Da	ate			Office Ling	GO HISPECIOI		
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
· ·		PAR #:										
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NCR:			WORK ORD	ER NON-CONFORI	MANCE (NCF	R)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval			
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